

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026658**Date Inspected:** 03-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman ACME**Location:** Buffalo, NY**CWI Name:** Reno Davis, John Crabtree**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge A**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Reno Davis Day Shift, and Mr. John Crabtree night shift. ABF Representatives are the Quality Control personnel for this location.

This QAI arrived at Watson Bowman Acme (WBA) and met with John Miller (WBA QC supervisor) and was informed that WBA would be working on the layout of the CA2 channels today. The welder Jayson Gray received the top plate with the bull nose applied for CA2-9. Mr. Gray has been working on grinding and cleaning all the areas where weldments would be placed to remove all mill scale and foreign material. This QAI observed that Mr. Gray had staged Back plates, Bottom plates and internal stiffeners for CA2-9 & 10 at the work station in preparations for Fit up. Channel CA2-10 was observed at the Computerized Numeric Cutting (CNC) station being prepared to receive the 13mm radius bull nose on the top plate.

This QAI also spoke with QCM Greg Ross concerning the status of the top plates, he stated that the remaining 14 plates that supposed to arrive at Private System from Samuels yesterday, did not arrive as planned. WBA had a meeting with Samuel's yesterday and this information was relayed.

The support plate (item SEI112667SP1, 2 and 3) are at Eagle Fabrication where the 19mm taper is to be applied. This QAI went to Eagle fabrication and spoke with Joe Molina the shop foreman, it was stated that Eagle would

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start the breaking process tomorrow morning at 0800hrs. This QAI informed Eagle Fabrication that this QAI would be onsite to witness this process.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC, and WBA personnel .

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riley,Ken	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
